

# Work Order ID 85714

June-14-12 8:22:55 AM

**\*85714\***

45673

Page 1

Item ID: D3916-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib Assembly

Start Date: 14/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/14 Tooling:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3916	A

100 0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- \*\*\* Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605

(3)

SMD 12-06-14  
PTO →

105

QC6- Inspect dimensions to drawing

0.00

**\*105\***

QC

Memo

0.00

Quality Control

Siribol

(13)

W/O: 85714		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3916-041 PAR #: \_\_\_\_\_ Fault Category: Scrap Fab NCR: Yes No DQA: Not Date: 12/06/27  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 12/06/27

NCR: 12-1512		WORK ORDER NON-CONFORMANCE (NCR) 172.71						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-06-14	100	Scrap <del>one</del> part on manual bender Clamp got loose when bending part	S AST/12/06/14	Scrap + destroy	SM 12-06-14	S 12/06/15	S AST/12/06/14	S 12/06/14
		R.L. Hammer Error SET-UP						

NOTE: Date & initial all entries

# Work Order ID 85714

June-14-12 8:22:55 AM

**\*85714\***

Page 2

Item ID: D3916-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib Assembly

Start Date: 14/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool #

Plan  
Code Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

107

Weld per dwg A/R S.S. rod Batch: M17/602

0.00

**\*107\***

Large Fab

Memo

0.00

Large Fab

1- weld bushing as per dwg D3916  
2- grind welds flush



CC 12-6-14

3 12-06-14

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

8/2/06/15

12-06-15

120

QC10- Inspect visual per QS1004- ground welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

8/2/06/15

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85714

**\*85714\***

Page 3

June-14-12 8:22:55 AM

Item ID: D3916-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib Assembly

Start Date: 14/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

(3x)

12-06-15

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/6/18

ME

12-06-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-14-12 8:23:00 AM

Page 1

Work Order ID: 85714

\*85714\*

Parent Item: D3916-041

\*D3916-041\*

Parent Item Name: Rib Assembly

Start Date: 14/06/2012

Required Date: 20/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	239.0000	7	28			

\*D3759-1\*  
Bushing

\*\*

CC 12-6-14

Location	Loc Qty	Loc Code
WA	163	
79213	1	
83464	162	
WA005	76	
66489	1	
82785	75	
	100	f
	82.5101	4.166

M304TS0.750W.049

Purchased

No

100 f

82.5101

4.166

17.54105

\*M304TS0 750W 049\*

304 SQ Tube .75x.75x.049W

\*\*

CC 12-6-14

Location	Loc Qty	Loc Code
MAT017	59.305937	
121898	59.305937	
MAT018	22.14169585	
119147	2	
119643	3.30639585	
121439	16.8353	
WA034	1.0625	
121087	1.0625	

B121898

17.5411

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

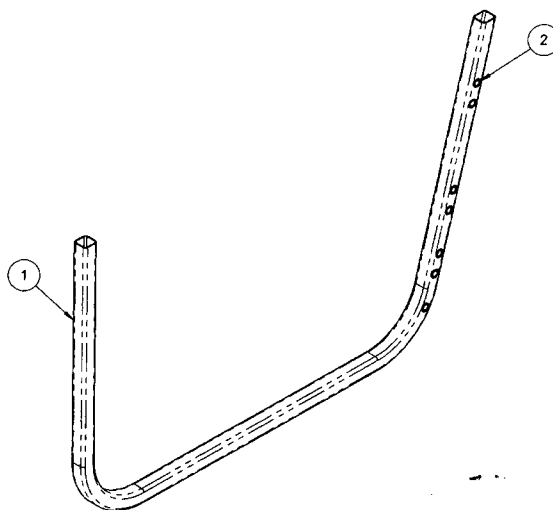
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

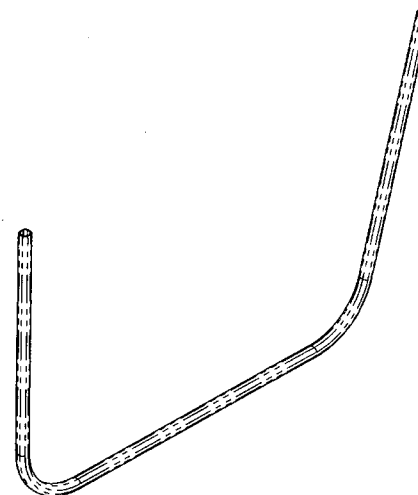
**NOTE:** Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



**D3916-041 RIB ASSY**



**D3916-5 LIGHT RIB**

NOT FOR USE  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK OR FOR

N. 05714 MWS

12/06/14

OK 10.12.21  
UNDER REVIEW

ADDITION OF HOLE + BUSHING  
ON D3916-041 RIBS.

**RELEASED**

2010-03-12

MW

A NEW ISSUE		JPH	10.03.04	
REV.	DESCRIPTION		DATE	
DESIGN	AIS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	<i>[Signature]</i>		DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>		D3916	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>		TITLE	SCALE
DE APPR.	<i>[Signature]</i>		RIB ASSY, 350 BASKET	NTS
DATE	10.03.04		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

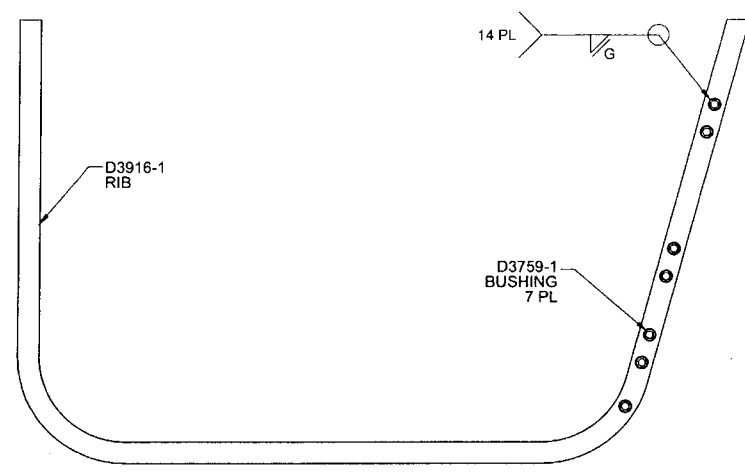
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

25714



**D3916-041 RIB ASSY**

**RELEASED**  
2010-03-12  
ANT

- NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: NONE  
 7) WEIGHT -041: 1.84 lbs  
 8) WELD PER DART QSI 004

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DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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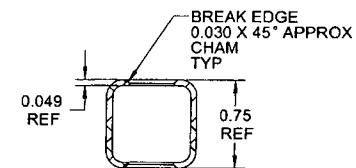
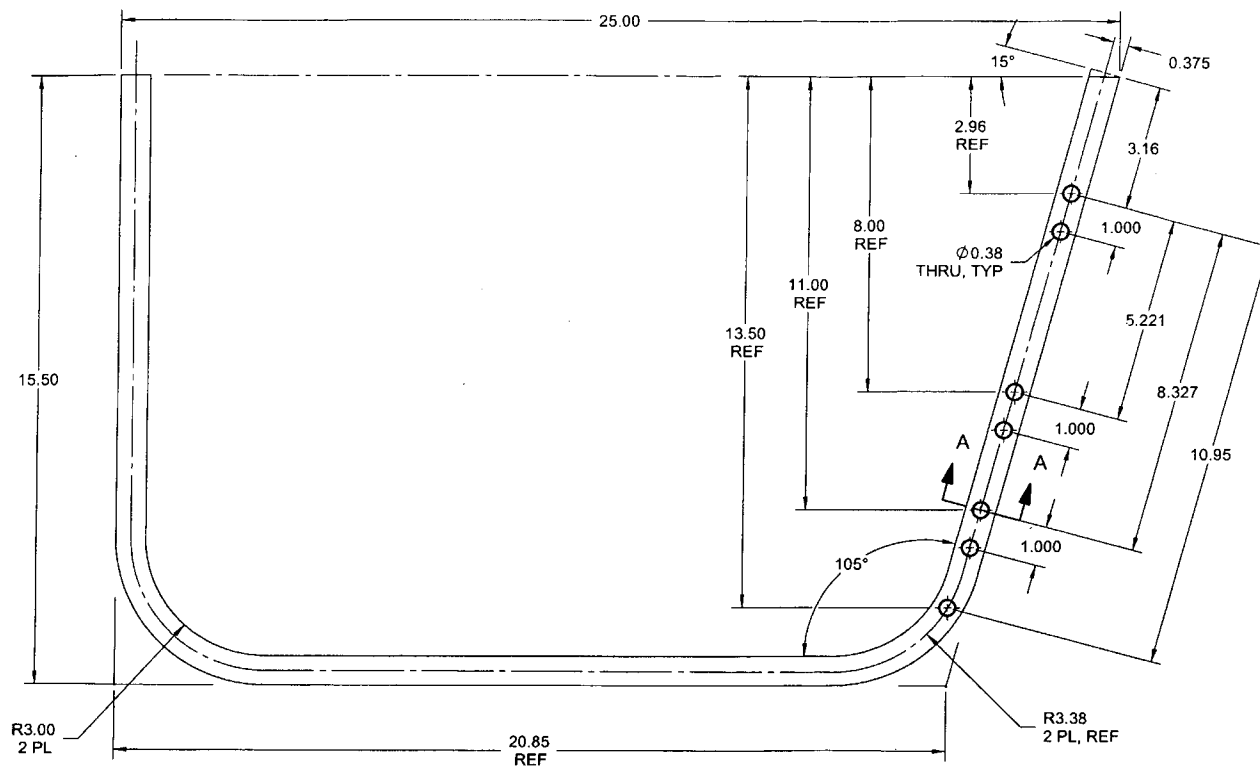
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



SECTION A-A

9 D3916-1 RIB

RELEASED  
2010-03-12  
NAD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

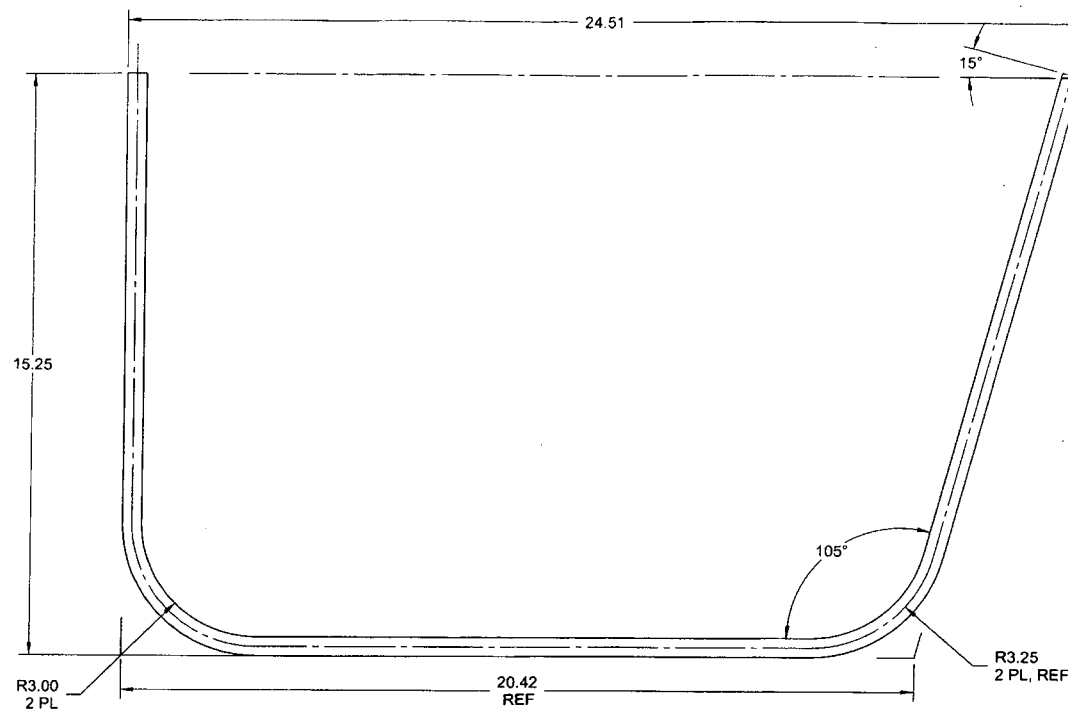
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

05714



9 D3916-5 LIGHT RIB

RELEASED  
2010-03-12  
JNP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE RIB ASSY, 350 BASKET	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	SCALE NTS	
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.04		

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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